

Ship July 20th

Monday, 7/10/2006 10:09:13 AM
User: Kim Johnston





Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT RH (FOLDING)
Job Number	: 27848		
Estimate Number	: 11653		
P.O. Number	: N/A	Part Number	: D2801042
This Issue	: 7/10/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2801 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A
Written By	: <u>SAK COMMENT BELOW</u>	Material	: N/A
Checked & Approved By	: <u>W 06.07.10</u>	Due Date	: 7/28/2006
Comment	Est B01.04.26 Changed D2802-042 to -2 EC		

Qty: 1 Um: Each

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2622120C	Extrusion
		
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)		
Qty	Part #	Description Batch:
1	D2622-120C	Extrusion <u>327077</u>
Check Material for any Dents or Defects		
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2622 extrusion to 86.15" long as per Dwg D2801		
2-Deburr and bevel ends for welding		
3.0	QCS	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
4.0	D2734	206 Step Endplate
		
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
2	D2734	End Cap <u>324402</u>

Training
FF 06.07.10
JE 06.07.10

Training
FF 06.07.10
JE 06.07.10

JE 06-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 27848

Part Number: D2801042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D28022

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2802-2 Arm 325709

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms as per Dwg D2801

Weld end caps as per Dwg D2801

Inspect for foreign object per QSI 024

Grind end cap welds flush

PL 06-07-11
PL 06-07-11
PL 06-07-11
FF 06-07-12

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-07-12

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PL 06-07-12

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-07-12

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 06-07-13

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Wing Walk per Dwg D2801 and QSI 005 4.4

SC 06/07/19
DL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-13		weld aft. end cap as per dwg	JS	06-07-13	1	u	JS
06-07-13		grind end cap flush	JS	06-07-13	1	u	JS
06-07-13		weld inspection	EPD	06-07-14	1		06-07-17
		touch up Hline on end caps	SAD	06-07-14	1	u	
			SAD	06-07-14	1		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/24.

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 27848

Part Number: D2801042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC#

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SR
06/07/19

~~ES/10 06-07-14~~ (1)

(PTO)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

~~SR~~

SR 06/07/19 (2)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SR 06.07.20

Job Completion



u 06.07.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06.07.20	12	QC 3 for wing walk inspection. perm. change					<i>[Signature]</i> 06.07.20	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

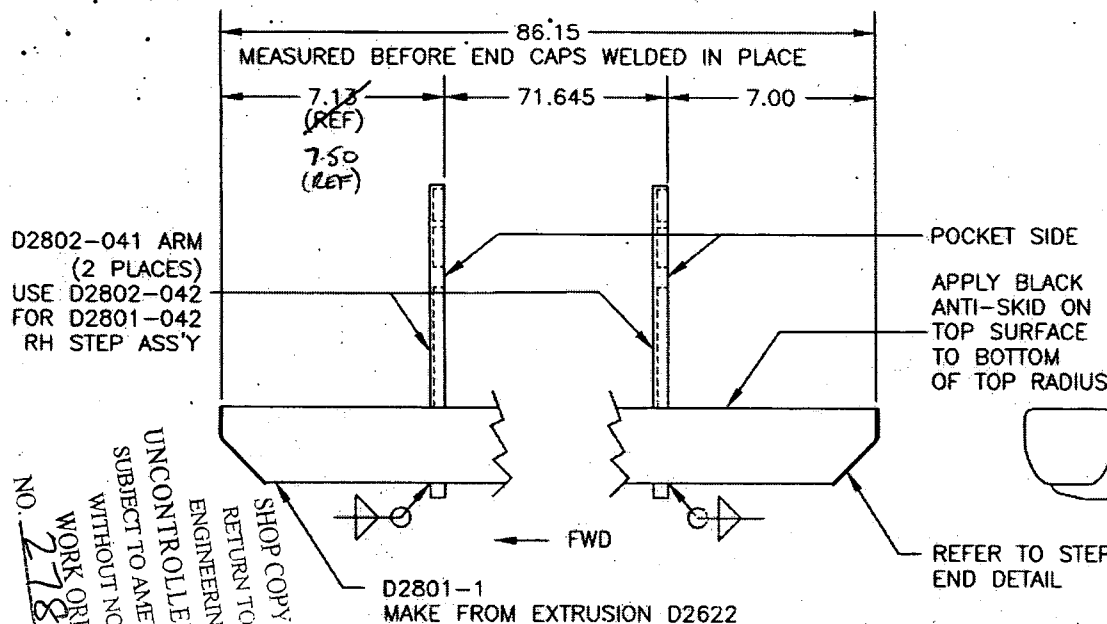
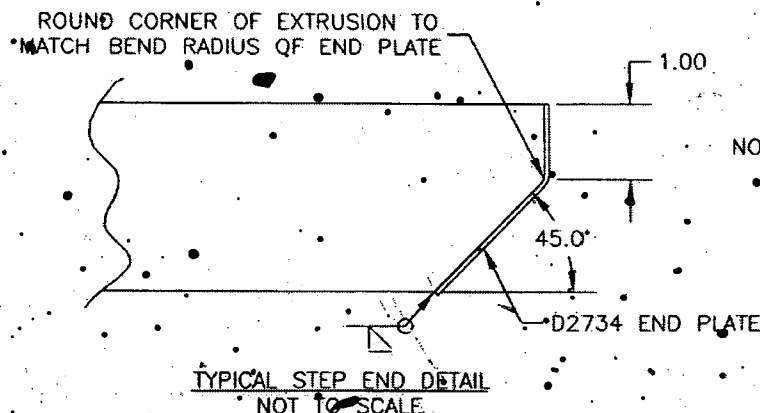
DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE STEP WELDMENT	REV. A
A	00.11.03	SHEET 1 OF 1
A1	03.08.16	SCALE NTS
	NEW ISSUE	
	7.50 WTS 7.13	

RELEASED
00.11.13

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

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WORK ORDER
NO. 27848

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